Work Orde February-12-14	er ID 113241 9:09:04 AM		*113	R241*							Page 1	
Item ID: Revision ID: Item Name:	D3459-3 Float Step Mounting Plate		Accept	*N900	040	100)*	Setup St	tart top			Ξ
Start Date: Required Date: Reference:	2/25/14 Start Qty: 12.00	*1 <i>9</i> * *1 <i>9</i> *		Cust Item 1 Customer:	ID:				•	^IVI	S2*	
Approvals:	Process Plan: MUS	Date: \\\-\\\\-\\\\	Tooling: SPC (Y/N):		ate:				tart top		R1* R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	*
Draw Nbr	Revision Nbr											
D3459	Rev A											
1 NN Waterjet FLOW CNC Waterje	FLOW WATER JET Memo 1-Cut as pe Dwg Rev: Prog Rev: 2-Deburr if	r Dwg D3459 A necessary	0.00				_12	. 0		,	Jm14-02	; 7
110 QC Quality Control	QC2- Inspect pårts off n Memo	nachine FAI/FAIB	0.00				_17	_ 0			Jm14-02-	·Z
120 *1 20* QC	QC8- Inspect parts - sec Memo	ond check	DAS 27 0.00 9-49 0.00 \U\2\3	Χ φ			<u>[]</u>					
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Quality Control

DQA:		-	Date:										0	TO AC
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATI	E		_		AEROSPACE
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Cause Design	-	Date	Step	Qty		or non-conformance	Cn	nief Eng	Description	····	Date	Verification	 	QC Inspector
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Work	Order	ID	113241

113241 Page 2 February-12-14 9:09:04 AM Item ID: D3459-3 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Float Step Mounting Plate **Start Date: Start Oty: 12.00** *12* 2/25/14 **Cust Item ID:** Required Date: 2/25/14 **Req'd Qty:** 12.00 *12* **Customer:** Reference: Start Run Process Plan: Date: **Approvals: Tooling:** Date: Stop Date: _____ QC: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID Description Run Hours** Number Stamp Code Qty Qty Identify as per dwg & Stock Location: 130 0.00 *120* 14-02-36 Packaging 0.00 Memo Packaging *** STOCK IN STEP CELL*** MLJ 1402-76 MK 14-2-26 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00 Memo Quality Control

DQA:		Date:	:					_						
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF				. d	_	AEROSPACE
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Work Orde	er:				DISPOSITION				AGAINST [DEF	PARTMENT	/PROCESS		
			···	_	Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
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Root				Desci	ription of work order update		nitial	Acti	ion	1	Sign &			
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		Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing		Weld
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		tion Strip ir	1 Tube	<u> </u>	Drawing	<u> </u>	Misrea							
		/Chatter			Drill Holes		Off-set							
:	_	g Sequence		<u> </u>	Finish	<u> </u>	1	Calibration						
	Wave/	Twist in Tu	be		Fit/Function	L	Out of:	Sequence						

February-12-14 9:09:17 AM

Work Order ID: 113241

113241

Parent Item:

D3459-3

D3459-3

Parent Item Name:

Float Step Mounting Plate

Start Date: 2/25/14

Required Date: 2/25/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev: A IPP Rev: B

New Issue 06-01-06 JLM waterjet 06-12-06 ec

Component Item ID/ **Item Name**

Replacement Mfg/ Item ID

Bin **Primary** Item Location

Last Location

Route Seq ID

Unit of Qty on Measure Hand

**

Qty per Kit Total

Qty **Issued Issued**

Date Status

M6061T6B0.187X04.00

Purchased

Purch

No

110

f

11.0500

0.347

4.383158

Qty

M6061T6B0 187X04 000

6061-T6 Bar .187 x 4.00

4.4

7m14-02-26

Location Loc Qty Loc Code MAT051 11.05 123279 10 125590 1.05

123279.

DQA:		_ Date:											•	
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Wo	ork Order up	odate only		AEROSPACE
Work Orde	er:				DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
Part N	lo		7374	_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Desci	ription of work order update		nitial	Acti	on		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	l	ief Eng	Descri	iption		Date	Verification	ł	QC Inspector
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		Not Conce	ntric	<u> </u>	BOM/Route	<u></u>	Grain			_	Over/Under	-	—	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			$\overline{}$	Part Incorred	⊢	_	Temperature/Cure
		ink/Ripple	e/Wave	<u> </u>	Burrs	_	1	ion Incomplete/Un	· .	_	Part Lost/Mi	ssing	→	Weld
	Cuffs			<u> </u>	Contamination	\vdash	-1	tions Incomplete/U	nclear	_	Part Moved			Wrong Stock Pulled
	Crushing			_	Countersink	\vdash	-1	gned/off center		-	Positioned V		_	
	Heat Tre			<u> </u>	Cut Too Short	<u></u>	Mislabe				Power Loss/	Surge	<u></u>	Other
	—	on Strip in	Tube	<u> </u>	Drawing	<u></u>	Misrea							
	Marks/0			\vdash	Drill Holes	<u> </u>	Off-set							
		Sequence		\vdash	Finish	\vdash	4	Calibration				· · · · · · · · · · · · · · · · · · ·		
	Wave/T	wist in Tu	be		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	113241
Description: Float Step Mounting Plate	Part Number:	D3459-3
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.259"	-		v	Jamo,
2.715	+/-0.010	2.716	_		V	
0.403	+/-0.010	0.4034	_		V	
R0.125	+/-0.010	0.125			RG	
R0.063	+/-0.010	0.063	_		R4	
0.839	+/-0.010	0.839"			ν	
0.188	+/-0.010	0.187			V	
3						
			,			
				.,,		
			DAS			

Measured by: Jm

Date: 14-03-26

Audited by: 9-89

Date: 1412136

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	
В	07.09.06	Dimensions added	KJ/JLM OK	E
				

